

Date: Thursday, 12/20/2007 3:17:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BLOCK
Job Number : 36465	
Estimate Number : 10324	
P.O. Number :	Part Number : D1049
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D1049 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 32797	Material :
Written By :	Due Date : 1/25/2008 Qty: 15. Um: Each
Checked & Approved By : <u>12-07-1221</u>	
Comment : Est RevC 02.04.10 Re-format NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
Material: 6061-T6 bar .750 wide x .250 thick.
Batch _____

M 19380 X 5 pcs
M 17869 X 10 pcs

J-F- 08/02/11

(15)

2.0	SHEAR	SHEAR
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Comment: SHEAR Band Saw
Cut Blanks: 2.000" long

J-F.

08/02/11

(15)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

J-F.

08/02/11

(15)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F.

08/02/11

(15)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

10 08/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/05/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 36465

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(15)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-02-12

7.0

POWDER COATING

POWDER COATING



M107005



(15X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-1 08/02/13

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-13

(15v)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 2

8/2/14 50 10x

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

H 08/02/14

Job Completion



min 2008/2/14

(15)



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

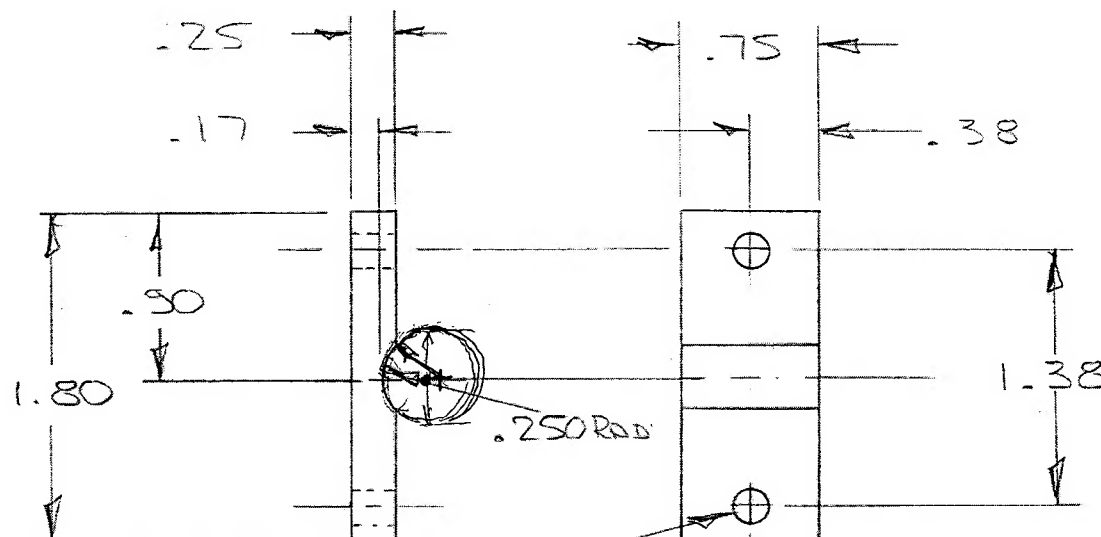
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 BW



.203 DIA.
TYP

MATERIAL : S052-H32

FINISH : POWDER COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36465

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DIA. DASH NO. W-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=HOLE DIGIT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN 142-47	DATE 1992			
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		TITLE SADDLE		
	GENERAL	LIMITS	B3=MS20470AD B5=MS20426AD		CHECKED		CODE		DWG NO. D1049
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .015 MAX 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - S - 7742 5. HOLES PER AND 10087	1. TOLERANCES — JOK ± .030 XXX ± .010 2. ANGLES ± .1° 3. PARALLELISM ± .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	CLIENT		SCALE		SHT	OF	REV
REPORT ALL DISCREPANCIES — DO NOT SCALE									